

**\*76000\***

Page 1

**\*N900040100\***

Setup Start \*NS1\*

Stop **\*NS2\***

\*40\*

**\*40\***

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

**Insp.  
Stamp**

AA 11.11.03

**\*100\***

0.00

Program Batch No. 24 Double check by: SPF 1-Machine Step No 1  
per Folio FA641 and inspect per attached Dimension Sheets2-Machine Step  
No 2 per Folio FA641and inspect per attached Dimension Sheets3-Machine  
Step No 3 per Folio FA641 and inspect p

0.00

**\*110\***

0.00

0.00

**\*120\***

0.00

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D35001 PAR #: \_\_\_\_\_ Fault Category: Machin NCR: Yes No DQA: Aut Date: 12/1/11  
NCR 11-1073 Resolution: Scrap Disposition: Scrap QA: N/C Closed: CL Date: 12/1/11

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/12/19	100	Flange thickness ".150" v/s .005 on left side. operator error. Machine offset error. R-L operator error /LOA	<u>MB</u> 11/12/23 0542	Scrap + Destroy QM +1	<u>BC</u> 11/12/19	<u>Y.A</u> 11/12/23	<u>MB</u> 11/12/23 0542	<u>S</u> 11/12/23

NOTE: Date & initial all entries

# Work Order ID 76000

**\*76000\***

Page 2

November-02-11 4:21:10 PM

Item ID: D3500-1 Accept **\*N9000040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle  
 Start Date: 02/11/2011 Start Qty: 40.00 **\*40\*** Cust Item ID:  
 Required Date: 16/11/2011 Req'd Qty: 40.00 **\*40\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 <b>*130*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00	<i>M-11-12-28</i>	11-12-28					
---	---	--------------	-------------------	----------	--	--	--	--	--

140 <b>*140*</b> Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo START TIME: <i>10:10</i> OVEN TEMPERATURE: FINISH TIME: <i>10:40</i>	0.00 0.00							
---	---	--------------	--	--	--	--	--	--	--

*W119480*

150 <b>*150*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00							
--	--------------------------------------	--------------	--	--	--	--	--	--	--

*39x φ M 12/01/02*  
*39x φ M 12/01/02*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Work Order ID 76000

\*76000\*

Page 3

November-02-11 4:21:10 PM

Item ID: D3500-1 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Saddle  
 Start Date: 02/11/2011 Start Qty: 40.00 \*40\* Cust Item ID:  
 Required Date: 16/11/2011 Req'd Qty: 40.00 \*40\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: <u>S1424</u>  Memo	0.00  0.00				M.L.J	12/01/02	(39)	
170 *170* QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00				CK	12/01/03		 MF 12-01-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

November-02-11 4:21:14 PM

Work Order ID: 76000

\*76000\*

Parent Item: D3500-1

\*D3500-1\*

Parent Item Name: Saddle

Start Date: 02/11/2011

Required Date: 16/11/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-013		Manufactured	No			100	Each	44.0000	1	40			

\*D6102-013\*

\*\*

Saddle Billet

Location

Loc Qty

Loc Code

MAT043

44

59467

3

60713

8

61300

1

70674

12

73492

20

76000

16

24

86 11/12/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 76000
<b>Description:</b> Saddle		<b>Part Number:</b> D3500-1
<b>Inspection Dwg:</b> D3500	<b>Rev:</b> C	<b>Page 1 of 1</b>

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.484	.484	.484		BC	11/12/20
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.382	.382	.382	.382		
F	0.490	0.510		.502	.502	.502	.502		
H				.525					
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.580	1.586	1.586	1.586		
J	0.240	0.260		.248	.250	.250	.250		
K	0.490	0.510		.502	.502	.502	.502		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.315	.315	.315	.315		
N	0.256	0.262		.257	.257	.257	.257		
O	6.500	6.520		6.513	6.513	6.513	6.513		
P	5.990	6.010		6.008	6.003	6.007	6.003		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.548	.552	.552	.552		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.130	1.135	1.135	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.255	.256	.256	.256		
AE	1.810	1.830		1.816	1.819	1.819	1.819		
AF	0.240	0.260		.251	.250	.250	.250		
AG	0.140	0.160		.149	.150	.149	.149		
AH	0.140	0.160		.158	.156	.156	.156		
AI	0.140	0.160		.159	.158	.158	.158		
Accept/Reject									

<b>Measured by:</b> BC
<b>Date:</b> 11/12/20

<b>Audited by:</b> H.A
<b>Date:</b> 11/12/23

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 76000
<b>Description: Saddle</b>		<b>Part Number:</b> D3500-1
<b>Inspection Dwg: D3500</b>	<b>Rev: C</b>	<b>Page 1 of 1</b>

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	7	8	By	Date
A	0.483	0.490		.484	.484	.484	.484	BF	11/12/20
B	1.175	1.185		1.170	1.170	1.170	1.170		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.382	.382	.382	.382		
F	0.490	0.510		.502	.502	.502	.502		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.585	1.585	1.585	1.585		
J	0.240	0.260		.253	.253	.253	.253		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.257	.257	.257	.257		
O	6.500	6.520		6.513	6.513	6.513	6.513		
P	5.990	6.010		6.003	6.003	6.003	6.003		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.552	.552	.552	.552		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.130	1.130	1.130	1.130		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.632	.632	.632	.632		
AD	0.240	0.260		.255	.255	.255	.255		
AE	1.810	1.830		1.819	1.820	1.820	1.820		
AF	0.240	0.260		.250	.250	.250	.250		
AG	0.140	0.160		.152	.153	.152	.152		
AH	0.140	0.160		.152	.153	.153	.153		
AI	0.140	0.160		.152	.153	.153	.153		
Accept/Reject									

Measured by: BF
Date: 11/12/20

Audited by: D.A.
Date: 11/12/23

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 76000
<b>Description: Saddle</b>		<b>Part Number:</b> D3500-1
<b>Inspection Dwg: D3500</b>	<b>Rev: C</b>	<b>Page 1 of 1</b>

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9 11	10 12	11 13	12 14	By	Date
A	0.483	0.490		.484	.484	.484	.484		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.501	.502	.501	.502		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.587	1.587	1.587	1.587		
J	0.240	0.260		.249	.249	.249	.249		
K	0.490	0.510		.501	.501	.501	.501		
L	3.590	3.650		1.620	1.620	1.620	1.620		
M	0.315	0.322		.315	.315	.315	.315		
N	0.256	0.262		.257	.257	.257	.257		
O	6.500	6.520		6.513	6.513	6.513	6.513		
P	5.990	6.010		6.004	6.004	6.004	6.004		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.553	.552	.552	.552		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.135	1.135	1.135	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.632	.632	.632	.632		
AD	0.240	0.260		.252	.255	.252	.252		
AE	1.810	1.830		1.821	1.820	1.821	1.820		
AF	0.240	0.260		.253	.252	.252	.252		
AG	0.140	0.160		.155	.155	.155	.155		
AH	0.140	0.160		.155	.155	.155	.155		
AI	0.140	0.160		.155	.155	.155	.155		
				.155					
Accept/Reject									

Measured by: <u>RL</u>
Date: <u>11/12/21</u>

Audited by: <u>B.S</u>
Date: <u>11/12/23</u>

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	76000
<b>Description: Saddle</b>		<b>Part Number:</b>	D3500-1
<b>Inspection Dwg: D3500</b>	<b>Rev: C</b>	<b>Page 1 of 1</b>	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	13 4	14 2	15 3	16 4	By	Date
A	0.483	0.490		.484	.484	.484	.484	JSK	11/12/21
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.500	.501	.501	.501		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595	<del>1.5845</del>	1.587	1.587	1.587	1.587		
J	0.240	0.260		.250	.250	.250	.250		
K	0.490	0.510		.501	.501	.501	.501		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.315	.315	.315	.315		
N	0.256	0.262		.257	.257	.257	.257		
O	6.500	6.520		6.513	6.513	6.513	6.513		
P	5.990	6.010		6.003	6.003	6.003	6.003		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.554	.554	.554	.554		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.137	1.137	1.137	1.137		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.632	.632	.632	.632		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.810	1.830		1.821	1.821	1.821	1.821		
AF	0.240	0.260		.250	.250	.250	.250		
AG	0.140	0.160		.155	.155	.155	.155		
AH	0.140	0.160		.155	.155	.155	.155		
AI	0.140	0.160		.155	.155	.155	.155		
Accept/Reject									

Measured by:	JSK /
Date:	11/12/21

Audited by:	B.A.
Date:	11/12/23

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	JSK

<b>DART AEROSPACE LTD</b>				<b>Work Order:</b> 76000	
<b>Description: Saddle</b>				<b>Part Number:</b> D3500-1	
<b>Inspection Dwg: D3500 Rev: C</b>				<b>Page 1 of 1</b>	

				<b>Recorded Actual Dimensions</b>					
Dim	Min	Max	Go/No Go Gauge	17 1	18 2	19 3	20 4	By	Date
A	0.483	0.490		.484	.484	.484	.484	SC	11/12/21
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.381	.381	.381	.381		
F	0.490	0.510		.501	.501	.501	.501		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.587	1.587	1.587	1.587		
J	0.240	0.260		.248	.248	.248	.248		
K	0.490	0.510		.501	.501	.501	.501		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.257	.257	.257	.257		
O	6.500	6.520		6.513	6.513	6.513	6.513		
P	5.990	6.010		6.003	6.003	6.003	6.003		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.553	.552	.553	.554		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.135	1.135	1.135	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.632	.632	.632	.632		
AD	0.240	0.260		.252	.252	.252	.252		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.252	.252	.252	.252		
AG	0.140	0.160		.155	.155	.155	.155		
AH	0.140	0.160		.155	.155	.155	.155		
AI	0.140	0.160		.155	.155	.155	.155		
<b>Accept/Reject</b>									

Measured by:	SC
Date:	11/12/21

Audited by:	H.A
Date:	11/12/23

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 76000
<b>Description:</b> Saddle		<b>Part Number:</b> D3500-1
<b>Inspection Dwg:</b> D3500	<b>Rev:</b> C	<b>Page 1 of 1</b>

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	21	22	23	24	By	Date
A	0.483	0.490		.484	.484	.484	.484	EC	11/12/22
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.382	.382	.382	.382		
F	0.490	0.510		.501	.501	.501	.501		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.585	1.585	1.585	1.585		
J	0.240	0.260		.248	.248	.248	.248		
K	0.490	0.510		.501	.501	.501	.501		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.257	.257	.257	.257		
O	6.500	6.520		6.513	6.513	6.513	6.513		
P	5.990	6.010		6.004	6.004	6.004	6.004		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.553	.553	.553	.553		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.135	1.135	1.135	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.632	.632	.632	.632		
AD	0.240	0.260		.255	.255	.255	.255		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.252	.252	.252	.252		
AG	0.140	0.160		.152	.152	.152	.152		
AH	0.140	0.160		.155	.155	.155	.155		
AI	0.140	0.160		.155	.155	.155	.155		
Accept/Reject									

<b>Measured by:</b> EC
<b>Date:</b> 11/12/22

<b>Audited by:</b> B.A
<b>Date:</b> 11/12/23

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA

<b>DART AEROSPACE LTD</b>				<b>Work Order:</b> 76000	
<b>Description: Saddle</b>				<b>Part Number:</b> D3500-1	
<b>Inspection Dwg: D3500</b>				<b>Rev: C</b>	
				<b>Page 1 of 1</b>	

				<b>Recorded Actual Dimensions</b>					
Dim	Min	Max	Go/No Go Gauge	25 A	26 2	27 2	28 A	By	Date
A	0.483	0.490		.484	.484	.484	.484	SG	11/12/22
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.382	.382	.382	.382		
F	0.490	0.510		.502	.502	.502	.502		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.585	1.585	1.585	1.585		
J	0.240	0.260		.248	.248	.248	.248		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.257	.257	.257	.257		
O	6.500	6.520		6.513	6.513	6.513	6.513		
P	5.990	6.010		6.003	6.003	6.003	6.003		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.552	.552	.552	.552		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.135	1.135	1.135	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.632	.632	.632	.632		
AD	0.240	0.260		.255	.255	.255	.255		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.250	.250	.250	.250		
AG	0.140	0.160		.152	.152	.152	.152		
AH	0.140	0.160		.155	.155	.155	.155		
AI	0.140	0.160		.155	.155	.155	.155		
<b>Accept/Reject</b>									

Measured by: <u>SG</u>
Date: <u>11/12/22</u>

Audited by: <u>B.A</u>
Date: <u>11/12/23</u>

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	<u>AA</u>

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 76000
<b>Description: Saddle</b>		<b>Part Number:</b> D3500-1
<b>Inspection Dwg: D3500</b>	<b>Rev: C</b>	<b>Page 1 of 1</b>

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	29 A	30 2	31 3	32 A	By	Date
A	0.483	0.490		.484	.484	.484	.484	BC	11/12/22
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.382	.382	.382	.382		
F	0.490	0.510		.502	.502	.502	.502		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.585	1.585	1.585	1.585		
J	0.240	0.260		.50246	.50246	.50246	.50246		
K	0.490	0.510		.501	.501	.501	.501		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.257	.257	.257	.257		
O	6.500	6.520		6.513	6.513	6.513	6.513		
P	5.990	6.010		6.003	6.003	6.003	6.003		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.554	.554	.554	.554		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.135	1.135	1.135	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.632	.632	.632	.632		
AD	0.240	0.260		.255	.255	.255	.255		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.252	.252	.252	.252		
AG	0.140	0.160		.152	.152	.152	.152		
AH	0.140	0.160		.155	.155	.155	.155		
AI	0.140	0.160		.155	.155	.155	.155		
Accept/Reject									

Measured by: <u>SL</u>
Date: <u>11/12/22</u>

Audited by: <u>B.A</u>
Date: <u>11/12/23</u>

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA



<b>DART AEROSPACE LTD</b>				<b>Work Order:</b> 76000	
<b>Description: Saddle</b>				<b>Part Number:</b> D3500-1	
<b>Inspection Dwg: D3500</b>				<b>Rev: C</b>	
				<b>Page 1 of 1</b>	

				<b>Recorded Actual Dimensions</b>					
Dim	Min	Max	Go/No Go Gauge	33 1	34 2	35 3	36 4	By	Date
A	0.483	0.490		.484	.484	.484	.484	g/r	11/12/23
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.382	.382	.382	.382		
F	0.490	0.510		.501	.501	.501	.501		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.585	1.585	1.585	1.585		
J	0.240	0.260		.246	.246	.246	.246		
K	0.490	0.510		.502	.502	.502	.502		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.257	.257	.257	.257		
O	6.500	6.520		6.512	6.512	6.512	6.512		
P	5.990	6.010		6.003	6.003	6.003	6.003		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.552	.552	.552	.552		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.135	1.135	1.135	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.632	.632	.632	.632		
AD	0.240	0.260		.255	.255	.255	.255		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.252	.252	.252	.252		
AG	0.140	0.160		.152	.152	.152	.152		
AH	0.140	0.160		.155	.155	.155	.155		
AI	0.140	0.160		.155	.155	.155	.155		
<b>Accept/Reject</b>									

Measured by: <u>g/r</u>
Date: <u>11/12/23</u>

Audited by: <u>B.A</u>
Date: <u>11/12/23</u>

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	<u>AA</u>

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 76000 23406
<b>Description:</b> Saddle		<b>Part Number:</b> D3500-1
<b>Inspection Dwg:</b> D3500	<b>Rev:</b> C	<b>Page 1 of 1</b>

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				37 4	38 2	39 3	4		
A	0.483	0.490		.484	.484	.484		36	11/12/23
B	1.175	1.185		1.180	1.180	1.180			
C	3.145	3.155		3.150	3.150	3.150			
D	1.175	1.185		1.180	1.180	1.180			
E	0.365	0.385		.382	.382	.382			
F	0.490	0.510		.501	.501	.501			
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.585	1.585	1.585			
J	0.240	0.260		.248	.248	.248			
K	0.490	0.510		.501	.501	.501			
L	3.590	3.650		3.620	3.620	3.620			
M	0.315	0.322		.316	.316	.316			
N	0.256	0.262		.257	.257	.257			
O	6.500	6.520		6.513	6.513	6.513			
P	5.990	6.010		6.003	6.003	6.003			
Q	2.820	2.830		2.825	2.825	2.825			
R	2.495	2.505		2.500	2.500	2.500			
S	2.245	2.255		2.250	2.250	2.250			
T	1.120	1.130		1.125	1.125	1.125			
U	0.540	0.560		.552	.552	.552			
V	0.793	0.803		.798	.798	.798			
W	R.240	R.260		.250	.250	.250			
X	0.040	0.060		.050	.050	.050			
Y	0.100	0.120		.110	.110	.110			
AA	R1.125	R1.145		1.135	1.135	1.135			
AB	R.490	R.510		.500	.500	.500			
AC	0.615	0.635		.632	.632	.632			
AD	0.240	0.260		.255	.255	.255			
AE	1.810	1.830		1.820	1.820	1.820			
AF	0.240	0.260		.252	.252	.252			
AG	0.140	0.160		.152	.152	.152			
AH	0.140	0.160		.155	.155	.155			
AI	0.140	0.160		.155	.155	.155			
Accept/Reject									

<b>Measured by:</b> 36/
<b>Date:</b> 11/12/23

<b>Audited by:</b> L.A.
<b>Date:</b> 11/12/23

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

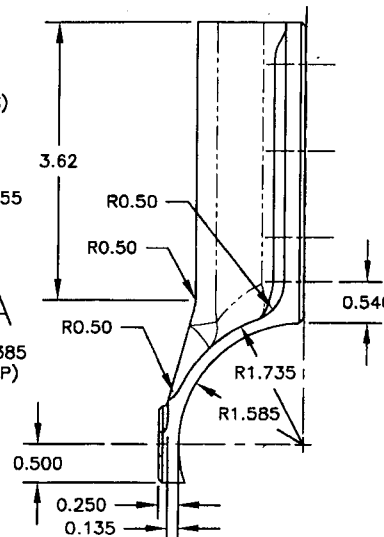
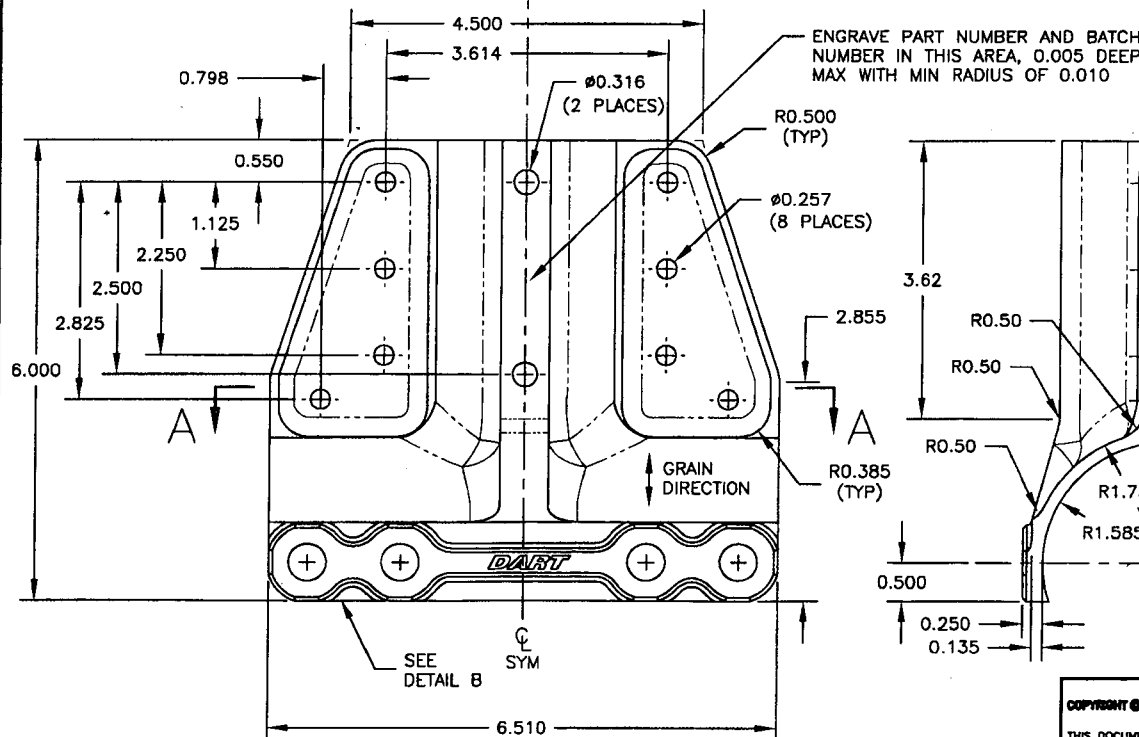
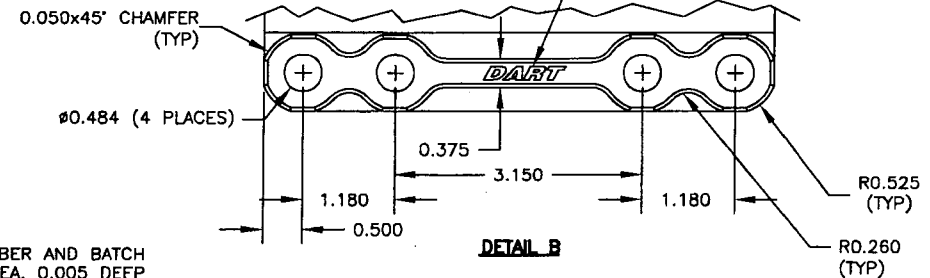
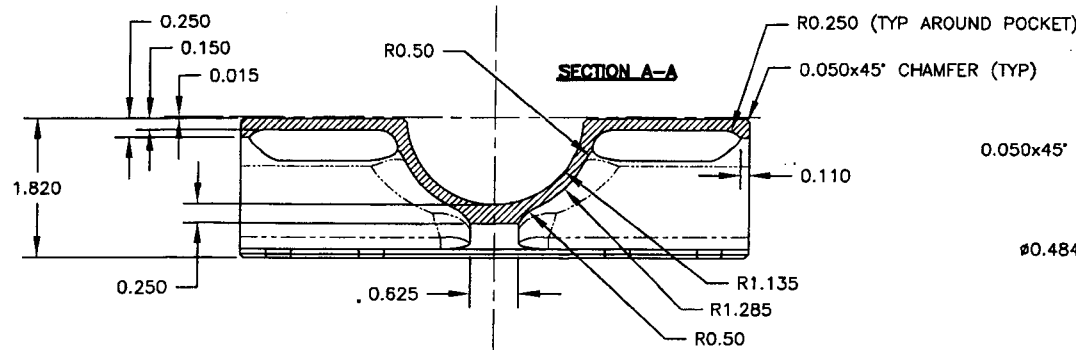
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 76000 M.C.J.

1111/03

ENGRAVE DART LOGO IN  
THIS AREA TO A MAX  
DEPTH OF 0.015 AND A MIN.  
TOOL RADIUS OF 0.250



### D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/11) (MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1, POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

06.08.15

C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	06.06.30	TITLE SADDLE
DRAWING NO. D3500		REV. C SHEET 1 OF 1
DART AEROSPACE LTD.		SCALE 2:3

COPYRIGHT © 2008 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL  
AND IS SUPPLIED ON THE EXPRESS CONDITION  
THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries